Work Order ID 123416 Thursday, August 07, 2014 11:15:06 AM		*129	Λ	Page 1	
Item ID: D3391-021 Revision ID: Item Name: Fwd Tube Assembly		Accept	*N900040	100* Setup Sta	
Start Date: 8/07/14 Start Qty: 1.00 Required Date: 8/07/14 Req'd Qty: 1.00 Reference:	*1* *1*		Cust Item ID: Customer:	- 0	
Approvals: Process Plan: ML5 QC:	•	Tooling: _ SPC (Y/N):	Date:	Run Sta	^IVH I ^
Sequence ID/ Operation Work Center ID Description		Set Up/ Run Hours	Tool ID Tool #	Plan Accept Reject Code Qty Qty	Reject Insp. Number Stamp
Draw Nbr Revision Nbr D3391 I					
*100 *100* Skidtubes Skidtubes Memo Cut as per de	wg.	0.00		19	1-8-20
110 *110* CNC Bend 1 CNC Delta 100 Bender BENDING MACHINE - Memo Bend as per	SKIDTUBES Dwg D3391 Using Bend Pro	0.00 0.00 og 3391021		D 14-	8-26
			H-	- 6.625	18
120 QC5- Inspect part complete A 1 20** QC Memo	leteness to step on W/O	0.00		1 9	14-08-26



Quality Control

DQA:			Date:											DART
QA Closed:			Date:			WORK ORDER NON	l-C(ONFO	RMANCE / UP		Vork Order ι	ıpdate only		AEROSPACE
				-		DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS		
Work Order	r: _						٦	i			7			
Part No	o. _				-	Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab		Water Jet od. Eng. Coor.		Engineering Quality Other
NCR No	o					Use-as-is	_	inern	noforming Large Fab	Finishing Composite	Rec/ste	ore/Packaging Supplier		Other
Root					Desc	ription of work order update		Initial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	n	QC Inspector
Design Doc/Data	_													
Equip/Tooling														
Handling/Pre	╗													
Material]		•			
Operator	┨													
Offset/Setup											ŀ			
Process	╗						İ							
Supplier														
Training												:		
Transport	\exists													
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			•	·	•		FA	ULT CAT	ΓEGORY					
Landin	g G	iear			,	General								
	_	Bending			$\cdot \sqcap$	Bend		Folio/P	rogram	Γ	Outside Dii	mensions	Pro	essure/Forced
] :. [Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Unde	r tolerance	Se	t-up
	\exists	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorr	eci	Te	mperature/Cure
was		Crimp/Kir	nk/Ripple	/Wave		Burrs	Г	Inspect	ion Incomplete/Und	qualified	Part Lost/N	1issing	w	eld
	٦	Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Part Move	1	w	rong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	Γ	Positioned	Wrong		
	-	Heat Trea	it			Cut Too Short	\sqcap	Mislabe		Γ	Power Loss	/Surge	Ot	her
	-	Inspectio		Tube		Drawing		Misread	d	-		·		
<u> </u>	$\overline{}$	Marks/Chatter Drill Holes			_		Off-set			•				
	_					Finish		4	Calibration					
]	_	Turning Sequence Wave/Twist in Tube		<u> </u>	Fit/Function		Out of	Sequence						

Work Order ID 123416 *123416* Page 2 Thursday, August 07, 2014 11:15:06 AM Accept D3391-021 Item ID: *N900040100* Setup Start **Revision ID:** Stop Item Name: Fwd Tube Assembly *1* **Start Oty:** 1.00 **Start Date:** 8/07/14 **Cust Item ID:** Required Date: 8/07/14 **Req'd Qty:** 1.00 *1* **Customer:** Reference: Start Run Process Plan: Date: **Tooling:** Date: Approvals: Stop Date: SPC (Y/N): Date: Tool ID Tool # Plan Reject Reject Sequence ID/ **Operation** Set Up/ Accept Insp. **Work Center ID** Code Qty Qty Number Stamp **Description Run Hours** 0.00 130 DAS HAAS CNC VERTICAL MACHINING #1 *120* 0.00 HAAS 1 Memo 1-Machine as per Folio FA590 HAAS CNC vertical machine #1 Rev. AA & Dwg D3391 Rev. Identify as D3391-1 2-Deburr DAS 140 QC2- Inspect parts off machine FAI/FAIB 0.00*140*

150

QC

150 Mill Conv

Quality Control

CONVENTIONAL MILLING MACHINE

Memo

Memo

0.00

0.00

0.00

Conventional Milling Machine

Drill X1 Aft cap as per Dwg D3391 .1875" dia

DQA:			Date:				*DART							
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		Vork Order up	odate only		AEROSPACE
		***				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS ,		
Work Orde	er:	·				D a a whi	ו		Chief tuba	Crosstube	\neg	Water Jet		Engineering
Part i	۱٥٠ ِ					Rework Scrap			Skid-tube Machining	Small Fab	_	d. Eng. Coor.		Quality
NCR I	۱o.					Use-as-is Suspected Unapproved	}	Therr	noforming Large Fab	Finishing _ Composite _	Rec/Stol	re/Packaging Supplier		Other
Root					Desci	ription of work order update		Initial	Acti	on	Sign &	-		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n	QC Inspector
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Handling/Pre			1											
Material														
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Offset/Setup														
Process														
Supplier														
Training														
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Landi	ng (Gear				General		_		_	<u> </u>	•		<u>.</u>
		Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં		Temperature/Cure
		Crimp/Ki	nk/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short	Г	Mislabe	eled	Γ	Power Loss/	Surge		Other
		Inspectio		Tube		Drawing		Misrea	d	_	_			
		Marks/Cl				Drill Holes		Off-set						
		Turning S				Finish		Out of	Calibration					
	Г	Wave/Twist in Tube Fit/Function			Fit/Function		Out of	Sequence			-			

Page 3

Work Order ID 123416 *123416* Thursday, August 07, 2014 11:15:06 AM Accept *N900040100* Item ID: D3391-021 Setup Start **Revision ID:** Stop **Item Name:** Fwd Tube Assembly *1* **Cust Item ID: Start Date:** 8/07/14 Start Qty: 1.00 Required Date: 8/07/14 **Reg'd Oty:** 1.00 *1* **Customer:** Reference: Start Run **Tooling:** Process Plan: Date: Date: **Approvals:** Stop Date: SPC (Y/N): Date: QC: Tool # Plan Reject Reject Insp. Sequence ID/ Operation Set Up/ Tool ID Accept Number Qty **Work Center ID** Code Qty Stamp Description **Run Hours** 0.00 QC2- Inspect parts off machine FAI/FAIB 160 *160* 0.00 Memo Quality Control

170

QC8- Inspect parts - second check

0.00

170 QC

Memo

DAS 37

9-89 14.10.15

0.00

Quality Control

DQA:			Date: _									DART		
			Data			WORK ORDER NON	-CC	ONFO	RMANCE / UF		ork Order up	ndata only [_	AEROSPACE
QA Closed:			Date:		. "						ork Order u	date only		
Work Order	·:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
					_	Rework	1		Skid-tube	Crosstube	1	Water Jet	T E	ngineering
Part No) .					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
			_			Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR No	o.			-		Suspected Unapproved			Large Fab	Composite		Supplier		
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Root					Desci	ription of work order update	I	nitial	Acti	ion	Sign &			
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification		QC Inspector
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Operator												·		
Offset/Setup														
Process .		1	i								·			
Supplier														
Training **	_					*					İ			
Transport		1	ĺ											
Unapproved														
							FAI	ULT CAT	TEGORY					
Landing	g Gear					General	_	1			7	_	_	•
\ <u>`</u>	—	iding			<u> </u>	Bend		1	rogram		Outside Dim	·	_	ssure/Forced
<u> </u>	Cen	itre Not	Concen	tric		BOM/Route	<u>_</u>	Grain			Over/Under	· -	_	t-up
	Cra					Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred		_	mperature/Cure
	Crit	np/Kink	:/Ripple/	/Wave		Burrs	L.	₹ '	ion Incomplete/Un	_	Part Lost/Mi	ssing	_ We	
i L	Cuf	fs	•		<u> </u>	Contamination			ions Incomplete/U	Inclear	Part Moved	L	Wr	ong Stock Pulled
		shing			.	Countersink		-	ned/off center	<u>. </u>	Positioned V	· · -		
	Hea	at Treat			, '	Cut Too Short		Mislabe	eled	· ·	Power Loss/	Surge	Oth	ner
	Insp	pection :	Strip in	Tube		Drawing	<u></u>	Misread	i					,
	Marks/Chatter Drill Holes			Drill Holes	Off-set									
	Turning Sequence					Finish		Out of 0	Calibration					
Ι Γ	Wave/Twist in Tube			Fit/Function	1	Out of S	Seguence							

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Thursday, August 07, 2014 11:15:06 AM

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Item ID: Revision ID:	D3391-021	and the second s			Accept	*N900	040	100) *	Setup Sta	:"1\	S1*	
Item Name:	Fwd Tube Ass	sembly								Sto	տ *//	S2*	
Start Date: Required Date	8/07/14 : 8/07/14	Start Qty Req'd Qt		*1 *1		Cust Item I Customer:	ID:						
Reference:	• 0,01,11.	1119 4 6	<i>J</i> • = • • •	~ 1	•	2 2333							
Approvals:	Process Pla	nn:		Date:	Tooling:	Da	ate:		I	Run Sta	^1 <i>V</i> 1	R1*	
	QC:			Date:	SPC (Y/N):	Da	ate:			Ste	» * N	R2 *	
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
180					0.00							\.	
120 Skidtubes		Skidtubes	Мето		0.00							<u> </u>	_
Skidtubes			1-Drill Remair holes drilled in		r tow cap using DT 8819 Locati	ng off of .1875"		*					
			holes to finish		wg D3391 using DT8798(Do no KED "A")	ot open tow cap	<u></u>		_				
			3-Open tow ca	ap holes to .208"	as per Dwg D3391		> BE	14-18	7-15				
	•		4-Open Tow R	Ring hole to .640	" as per Dwg D3391		_						
			5- open float b	pag holes 0.328"	and counter sink as per dwg D3	391)						
	•		6-Deburr & Sc	cribe Batch numb	per Inside aft end.								
			7-Transfer dril ***NO WEAF MID TUBE B	II D3391-021 wi RPLATE HOLES ATCH#/2	ith D3391-023 SARE TRANSFER DRILLED*		14	-10	-15	-			

DQA:			Date:			DART								
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDA		ork Order up	date only		AEROSPACE
						DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Work Orde	r: -						ı		a		1	Matan lat		l Casinopring
Part N	o	<u>.</u>				Rework Scrap		i e	Machining S	rosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	lo.			····	<u>_</u>	Use-as-is Suspected Unapproved		mem	~ 	omposite	, Rec/Stor	Supplier	-	Other
Root					Desc	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verificatio	n	QC Inspector
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Handling/Pre	-													
Material						·								
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Offset/Setup														
Process #														
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[_	Bending		•		Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up į
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	i		Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqual	lified	Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Uncle	ear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned W	/rong		
		Heat Trea				Cut Too Short	Г	Mislabe			Power Loss/S	Surge		Other
	_	Inspectio		Tube		Drawing		Misread	d		-			
	$\overline{}$	Marks/Cl				Drill Holes		Off-set						
]		Turning S				Finish		4	Calibration					
		Wave/Tw			<u> </u>	Fit/Function		Out of	Sequence					

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Thursday, August 07, 2014 11:15:06 AM Item ID: Accept D3391-021 *N900040100* Setup Start Revision ID: Stop Item Name: Fwd Tube Assembly *1* **Start Oty:** 1.00 **Cust Item ID: Start Date:** 8/07/14 Required Date: 8/07/14 **Rea'd Otv:** 1.00 *1* **Customer:** Reference: Run Start **Tooling:** Process Plan: Date: Date: Approvals: Stop SPC (Y/N): Date: QC: Date: Tool ID Tool # Plan Reject Reject Set Up/ Accept Insp. Sequence ID/ **Operation** Number Stamp Work Center ID **Description Run Hours** Code Qty Qty QC5- Inspect part completeness to step on W/O 0.00 190 *100* 0.00 Memo Quality Control Chemical Conversion Coat per QSI005 4.1 0.00 200 *200* 0.00 HandFinish Memo Hand Finishing 0.00 **OC7-Inspect Chemical Conversion Coat** 210 0.00 OC Memo Quality Control

DISPOSITION Rework Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Quality Other	DQA:			Date:											
Work Order: Part No.							WORK ORDER NON-	-CC	ONFO	RMANCE / UPE			ı	AERO	SPACE
Rework Scrap Use-as-is Suspected Unapproved Suspected Unap	QA Closed:			Date:							W	ork Order up	date only		
Rework Scrap Use-as-is Suspected Unapproved Use-as-is Suspected Use-as-is Suspected Unapproved Use-as-is Suspection Use-as-is Sus	NA Comba Orda						DISPOSITION				AGAINST DE	EPARTMENT,	PROCESS		
Part No.	Work Orde	er: .					Pawork	ı		Skid-tube	Crosstube	7	Water let	Fngineerin	ıg
NCR No. Suspected Unapproved Thermoforming Large Fab Composite Supplier Other Su	Part N	jo.					l <u>—</u>			─ ─		Pro		<u> </u>	·
Root Cause Date Step Oty Description of work order update Initial Action Date Verification OC Inspector	, are r	•••					· -			· —		≓	-		· —
Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data EquipyTooling Lauding/Pre Landing/Pre Landing Gear General Description Description Date Verification QC Inspector FAULT CATEGORY FAULT CATEGORY Landing Gear General Bending Centre Not Concentric Caraks Gring Morkoute Broken/Damage/Defect Broken/Damage/Defect Inspection Incomplete/Unqualified Curfs Curshing Heat Treat Countersink Mislabeled Missalegined / Great Mislabeled Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Misread Misread Initial Action Date Verification QC Inspector Date Verification	NCR N	lo.									~	1			
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Handling/Pre		•										-			
Design Doc/Data Equip/Tooling Handling/Pre	Root					Desc	ription of work order update	١	Initial	Action	n	Sign &			
Doc/Oata Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Training Training Centre Not Concentric Bend Grain Over/Under tolerance Cracks Broken/Damage/Defect Hardware Part Incorrect Temperature/Cure Temperature/Cure Cracks Crimp/Kink/Ripple/Wave Cuffs Countersink Countersink Countersink Countersink Countersink Countersink Misalabeled Power Loss/Surge Other Other Cother Cot	Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verificatio	n QC Inspe	ctor
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Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Unapprov	Doc/Data														
Material Operator Offset/Setup Offset/Setup Offset/Setup Process Supplier Training Training Output Offset Offset/Setup Output Offset/Setup Offset/Se	Equip/Tooling							ļ							
Opfset/Setup Process Supplier Training Transport Unapproved Bending Bend Folio/Program Outside Dimensions Pressure/Forced Set-up	Handling/Pre														
Offset/Setup Process Supplier Training Transport Unapproved Bending Bend Bend General Centre Not Concentric Broken/Damage/Defect Hardware Part Incorrect Temperature/Cure Temperature/Cure Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld Wrong Stock Pulled Crushing Countersink Misaligned/off center Power Loss/Surge Other Oth	Material														
FAULT CATEGORY Canding Gear General Folio/Program Outside Dimensions Pressure/Forced Set-up Grain Over/Under tolerance Set-up Temperature/Cure Outside Dimensions Over/Under tolerance Set-up Temperature/Cure Outside Dimensions Over/Under tolerance Over/Under toler	Operator														
Supplier Training Transport Unapproved	Offset/Setup													İ	
Training Transport Unapproved FAULT CATEGORY Landing Gear General Bending Centre Not Concentric Cracks Broken/Damage/Defect Hardware Inspection Incomplete/Unqualified Crushing Countersink Misaligned/off center Crushing Countersink Misaleled Inspection Strip in Tube Drawing Misread FAULT CATEGORY FAULT CATEGORY FAULT CATEGORY FAULT CATEGORY FAULT CATEGORY FOlio/Program Outside Dimensions Over/Under tolerance Set-up Part Incorrect Temperature/Cure Inspection Incomplete/Unqualified Part Lost/Missing Weld Wrong Stock Pulled Part Moved Wrong Power Loss/Surge Other	Process														
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Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up Temperature/Cure Crimp/Kink/Ripple/Wave Cuffs Contamination Instructions Incomplete/Unqualified Part Lost/Missing Weld Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Missade Drawing Misread Poutside Dimensions Over/Under tolerance Set-up Temperature/Cure Part Lost/Missing Weld Part Moved Wrong Stock Pulled Power Loss/Surge Other								FAI	ULI CAI	IEGORY					
Centre Not Concentric BOM/Route Grain Over/Under tolerance Cracks Broken/Damage/Defect Hardware Part Incorrect Temperature/Cure Weld Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Contamination Mislabeled Mislab	Landi		3				7	_]!;_/n) = 0 = 10 = 10 = 10 = 10 = 10 = 10 = 10	Γ	Joursida Dim	oncions	Drossuro/For	cod
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Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread		\vdash	1	ot Concer	itric	\vdash	· ·	⊢		aro.	 	⊣			/Cure
Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread		 	ł	al /Binnla	Maya	-	1	\vdash	4		ualified	[Curc
Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread			1	ik/kippie	/ vvave	-	1	<u> </u>	4 '	·			331116		Pulled
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Inspection Strip in Tube Drawing Misread	İ	\vdash	1	. +		-		-	- ·		-	-	-	Other	
		_	4		Tube			-	4		L	٦. ٥٠٠٠٠ - ١٥٠٥/٠		1	
		<u> </u>	1		, une		Drill Holes	<u> </u>	Off-set			-			
						Out of Calibration									
		Wave/Twist in Tube			∔		4								

Work Or	der ID	123416
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Thursday, Augu	st 07, 2014 1	1:15:06 AM		1/.)4 ()								
Item ID: Revision ID: Item Name:	D3391-021 Fwd Tube Ass	sembly		Accept	*N900	040	100	ን * s	Setup S	Start Stop		S1*	
Start Date: Required Date: Reference:	8/07/14 8/07/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:					, ,		
Approvals:	Process Pla	ın:		Tooling:	Da	ate:		R		Start	*NI	R 1*	
	QC:		Date:	SPC (Y/N):	Da	ate:	··········		S	Stop	*NI	₽2*	
Sequence ID/ Work Center II 220 **77* Skidtubes Skidtubes	D	exp. date:/ cure time 12 2- grind cro	crossbolt if necessary	Set Up/ Run Hours 0.00	Tool ID 14-16	Tool #	Code		Rejec Qty		leject lumber	Insp. Stamp	_
230 QC Quality Control	·	Мето		0.00				<u>3</u>	<u> </u>	<u>1002</u>	<u>8</u>	9-89	
235 *935* HandFinish Hand Finishing		Pressure Wash per QSI0 Memo AND REAL	05 4.3 LODINE AS PER QSI 0	0.00 0.00				· \\	4	يل	U i	1/10/	32

DQA:			. Date:											
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDATE		ork Order up	date only		AEROSPACE
			****			DISPOSITION			AGA	INST DE	PARTMENT,	/PROCESS		
Work Orde	er: .					S	1		Clist Auto Conne		1	Water Jet		nooring
Part N	10.					Rework Scrap			У Щ	ll Fab	4	d. Eng. Coor.		neering Quality Other
NCR I	۱o. ِ				<u> </u>	Use-as-is Suspected Unapproved		inerr	noforming Finis Large Fab Comp	shing osite	Rec/Stor	e/Packaging Supplier		Other
Root		**********	[]		Desc	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	n QC	Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material				:										
Operator					,									
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
							FA	ULT CA	TEGORY					
Landi	ng (Gear				General		_			-	-		
		Bending				Bend		Folio/F	Program	<u> </u>	Outside Dim	ensions	Pressu	re/Forced
į		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up)
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં [Tempe	rature/Cure
l ł		Crimp/Ki	nk/Ripple	/Wave		Burrs		inspect	ion Incomplete/Unqualified	j [Part Lost/Mi	ssing	Weld	
,		Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong	Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong _		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/:	Surge	Other	
1		Inspectio	n Strip in	Tube		Drawing		Misread	d					
		Marks/Cl				Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	vist in Tub	e		Fit/Function Out of Sequence								

Work O	rder ID	1	23416
Thursday, Ai	igust 07, 20.	14	11:15:06
Item ID:	D3391-	02	1

Thursday, Augu				*1 <i>つ</i> :						Pag	ge 7		
Item ID: Revision ID: Item Name:	tewision ID: The sem Name: Fwd Tube Assembly			Accept	*N900	0040	100)*	Setup	Start Stop		S1*	•
Start Date: Required Date: Reference:	8/07/14 : 8/07/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:								
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		Pate: Pate:			Run	Start Stop	^I <i>V</i>	R1* R2*	t t
Sequence ID/ Work Center II 240 *740* Powdercoat Powder Coating	D	Operation Description White Gloss(Ref:4.3.5.1 Memo START TIN OVEN TEN FINISH TIN	&) ∛. ME/iJ5: 22.	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accep Qty	Qty		Reject Number	Insp. Stamp	DAS 34
250 */ COC Quality Control		QC3- Inspect Part Finis Memo	h	0.00	•			12	<u>d</u>	JL	14/1	103	DA: 16 9-8
254 */ S.4* HandFinish Hand Finishing		Assemble as per dwg Memo		0.00				<u>_</u> &&	·)le 6	(he	tos

DQA:			Date:				-							DART
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE		AEROSPACE			
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Work Orde	-					Rework	ı		Skid-tube Crosstube	,		Water Jet		Engineering
Part N	lo.					Scrap		ĺ	Machining Small Fat	Ē		d. Eng. Coor.		Quality
NCR N	lo.					Use-as-is Suspected Unapproved		Therr	noforming Finishing Large Fab Composite	-	Rec/Stor	e/Packaging Supplier		Other
Root					Desci	ription of work order update		nitial	Action		Sign &			
Cause	١	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material							l							
Operator														
Offset/Setup														
Process														
Supplier														
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Transport				,										
Unapproved														
							FA	ULT CA	TEGORY					
Landi	ng G	Gear				General		_		_	•	-		
		Bending				Bend	L	Folio/f	Program	L	Outside Dim	ensions		Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં [Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
· •		Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved	Į		Wrong Stock Pulled
		Crushing				Countersink]Misali	gned/off center		Positioned V	/rong		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	hatter			Drill Holes		Off-set						
		Turning S	Sequence			Finish		Out of	Calibration					
<u> </u>		Wave/Tv	vist in Tub	oe .		Fit/Function		Out of	Sequence					

Work Order ID 123416	W	ork	Ordei	r ID	12341	6
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Page 8 Thursday, August 07, 2014 11:15:06 AM Accept D3391-021 Item ID: *N900040100* Setup Start **Revision ID:** Stop Item Name: Fwd Tube Assembly *1* **Start Oty: 1.00 Start Date:** 8/07/14 **Cust Item ID:** Required Date: 8/07/14 Reg'd Oty: 1.00 *1* **Customer:** Reference: Start Run Date:____ **Approvals:** Process Plan: **Tooling:** Date: Stop Date: QC: Date: SPC (Y/N): Set Up/ Tool ID Tool # Plan Reject Reject Insp. Sequence ID/ Operation Accept Work Center ID **Run Hours** Code Oty Oty Number Stamp **Description** DAS 256 QC5- Inspect part completeness to step on W/O 0.00 *256* 0.00 Memo Quality Control 0.00 D 412.742.043/BIIS 196 1x of Al 14/11/03 Identify as per dwg & Stock Location: w \ O 260 *260* Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 280 *****280* 0.00 QC Memo Quality Control

DQA:			Date:			. WORK ORDER NON	~	0NICO1	DART				
QA Closed:			Date:			WORK ORDER NON	-((JNFUI	RIVIAINCE / UP		ork Order up	odate only	AEROSPACE
Work Ord	or:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
WORK OT U	E1.					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No. _.			·	<u></u>	Scrap Use-as-is		li .	Machining noforming	Small Fab Finishing	-	d. Eng. Coor. re/Packaging	Quality Other
NCR I	۷o. _.					Suspected Unapproved		Hien	Large Fab	Composite	_ Kec/stor	Supplier	
Root					Desc	ription of work order update		Initial	Actio	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
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Doc/Data													
Equip/Tooling													
Handling/Pre													
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Process							l						
Supplier			1										
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Transport													
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							FA	ULT CA	TEGORY				
Landi	ng (Gear				General		_			_	_	
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં _	Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld
:		Cuffs				Contamination		instruct	tions Incomplete/U	nclear	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong _	
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d				
	Г	Marks/Cl	hatter			Drill Holes		Off-set					
		Turning S	Sequence			Finish		Out of 0	Calibration				
				Fit/Function		Out of	Sequence						

Thursday, August 07, 2014 11:15:04 AM

Work Order ID: 123416

123416

D3391-021

Parent Item Name: Fwd Tube Assembly

D3391-021

Start Date: 8/07/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

IPP A05.09.13New issue

KJ/JLM

IPP B06.02.10Dwg rev.D ecn 773 EC IPP C06.05.02Added inspections EC

IPP D 07.03.13 rev F dwg

EC

IPP E 07.11.07 revG dwg ecn1053P

EC verified by: DD

IPP Rev:f ECN 1056 07-11-12 DD

verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev I 09.02.02 added hardware EC verifified by: DD IPP Rev:J

11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date S Issued	Status
D4095-051		Manufactured	No				Each	33.0000		1			
D4095-09	51								**		II i	1100	3

wearpad Assembly				
	Location	Loc Oty	Loc Code	
	FP001	33		
	108291	1		
	116096	20		X (

120520

D6013-047

Manufactured No 100

160.0000

Loc Qty Location

LG003

160 36

12

Each

124

Loc Code

Skidtube Material

DQA:			Date:											TAART	
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:							V	Vork Order up	odate only			
Mark Orde						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS			
Work Orde	21.			···		Rework	1		Skid-tube	Crosstube		Water Jet		Engineering	
Part N	۱o.					Scrap			Machining	Small Fab		d. Eng. Coor.		Quality	
NCR N	١٥٠ ِ			····		Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier		Other	
Root					Desci	ription of work order update		nitial	Acti	on	Sign &			_	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verificatio	n	QC Inspector	
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Unapproved				i										AND IN THE RESERVE OF THE PARTY	
			<u> </u>				FA	ULT CA	TEGORY					<u> </u>	
Landi	ng (1				General]		r	Tauriu			Danasana /Fanasad	
	<u> </u>	Bending			<u> </u>	Bend	-	4	Program	-	Outside Dim		-	Pressure/Forced	
	<u> </u>	Centre N	ot Concer	ntric		BOM/Route	<u> </u>	Grain		-	Over/Under		\dashv	Set-up	
	<u> </u>	Cracks	l /n:		-	Broken/Damage/Defect	\vdash	Hardwa			Part Incorred		$\overline{}$	Temperature/Cure	
	<u> </u>	Crimp/Kii	nk/Rippie	/Wave	-	Burrs	-	1	ion Incomplete/Un		Part Lost/Mi	ssing	\dashv	Weld	
	ļ	Cuffs			\vdash	Contamination		4	tions Incomplete/U	nciear	Part Moved			Wrong Stock Pulled	
	<u> </u>	Crushing			<u> </u>	Countersink	\vdash	4 .	gned/off center	}-	Positioned V	_		Other	
		Heat Trea		T., b -	<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss/	ourge	l	Other	
	-	Inspectio	-	ıupe	<u> </u>	Drawing	\vdash	Misread				* ##* *			
	\vdash	Marks/Ch				Drill Holes	\vdash	Off-set							
	<u> </u>	Turning S	-		<u> </u>	Finish	\vdash	┪	Calibration						
1	l	Wave/Tw	ist in Tub	e		Fit/Function		Out of :	Sequence						

Thursday, August 07, 2014 11:15:05 AM

Work Order ID: 123416

123416

Parent Item:

D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 8/07/14

Required Date: 8/07/14

while 3

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured

220

Each 202.0000

**

**

D3670-4-200

Bushing

Loc Qty Location FG 10 87709 10 LG001 192

103880 109108

2 190 Each 22.0000

Loc Code

D3401-041

Manufactured

Tow Cap Assembly

Location	Loc Qty	Loc Code
FP001	22	
103868	2 .	

109127 7 92680 94116 11 94303

DQA:			Date:			•							*DAF	2 T
			Data			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only AEROSPACE								
QA Closed:			Date:			<u>r</u>					TOIR Order up	date only		
Work Orde	r.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
WOIR OIGE	-					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	_
	•					Use-as-is	1	Therr	moforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier		
			·	-		<u> </u>			T] c: 0	<u></u>		
Root		_	_	_	Desc	ription of work order update	ı	nitial	Actio		Sign &) /	00 1	.
Cause	4	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	QC Inspec	tor
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Equip/Tooling	_													
Handling/Pre	_													
Material														
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Offset/Setup	_													
Process	_										}			
Supplier	_						ļ							
Training														
Transport	_										ļ			
Unapproved		<u> </u>			<u> </u>				<u> </u>		<u> </u>			
			_				FA	ULT CA	TEGORY					
Landir	$\overline{}$					General	_	1	_	_	٦		¬- ,-	
		Bending				Bend	\vdash	4 .	Program	ļ	Outside Dim		Pressure/Force	d
]		Centre No	ot Concer	ntric	_	BOM/Route		Grain		<u> </u>	Over/Under	-	Set-up	
		Cracks				Broken/Damage/Defect	_	Hardwa		L	Part Incorred	-	Temperature/C	ure
		Crimp/Kii	nk/Ripple	/Wave		Burrs	<u></u>	4	ion Incomplete/Unc	<u> </u>	Part Lost/Mi	ssing	Weld	
		Cuffs			_	Contamination	<u>_</u>	4	tions Incomplete/Ur	nclear	Part Moved	L	Wrong Stock Pu	ılled
		Crushing			_	Countersink	L	1 1	gned/off center	<u>L</u>	Positioned V		—	
		Heat Trea	at		<u> </u>	Cut Too Short		Mislab			Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	Sequence			Finish		Out of	Calibration					
		Wave/Tw	vist in Tub	e		Fit/Function		Out of	Sequence			LUID .		

Thursday, August 07, 2014 11:15:05 AM

Work Order ID: 123416

123416

Parent Item:

D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 8/07/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

5,109.000

10

NAS1149C0332R

WASHER

Location		Loc Qty	Loc Code	•
CA		83		
1	m129682	83		
ST278		5026		-
	122063	41		
	125654	609		
1	m126319	61		
1	m127306	2500		<u> </u>
1	m127410	543		
1	m127831	26		
1	m128591	75		
1	m129390	142		
1	m129499	183		
1	m129909	846		
		Fach	2 445 000	10

AN3C4A

Purchased

**

AN3C4A

Locatio	<u>n</u>	Loc Qty	Loc Code	
FG		20		
	122814	20		
ST350		2425		<u> </u>
	124221	12		
	125388	3		
	M127410	1		
	M127832	62		
	M128606	32		
	M128634	8		
	M128739	4		
	M128879	71		
	M129520	2232		<u> </u>

DQA:			Date:				TOART								
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:							W	ork Order up	date only			
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS			
WORK OIG	٠.					Rework	1		Skid-tube	Crosstube	٦	Water Jet	П	Engineering	
Part I	۷o. ِ					Scrap			Machining	Small Fab		d. Eng. Coor.		Quality	
NCR I	۷o. ِ	s				Use-as-is]	Thern	noforming Large Fab	Finishing Composite	Rec/Stoi	e/Packaging Supplier	${m -}$	Other	
Root					Desc	ription of work order update		nitial	Acti	on	Sign &			·	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verificatio	n	QC Inspector	
Design									-						
Doc/Data															
Equip/Tooling					ļ										
Handling/Pre	Ш														
Material	Ш												l		
Operator			Ì										l		
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Process	Ш														
Supplier															
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Unapproved ¹							<u> </u>								
							FA	ULT CAT	regory						
Landi	ng (Gear				General				_	-		_		
		Bending				Bend		Folio/F	Program		Outside Dim			Pressure/Forced	
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under		⊢⊣	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ાં	Ш	Temperature/Cure	
!		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Ш	Weld	
		Cuffs				Contamination	L	Instruct	tions Incomplete/U	nclear	Part Moved			Wrong Stock Pulled	
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong			
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other	
		Inspectio	n Strip in	Tube		Drawing		Misread	b						
		Marks/Cl	natter			Drill Holes		Off-set							
		Turning S	Sequence			Finish		Out of 0	Calibration						
		Wave/Tw	vist in Tub	oe		Fit/Function		Out of 9	Sequence						

Picklist Print

Thursday, August 07, 2014 11:15:05 AM

Page 4

Work Order ID: 123416

123416

Parent Item:

D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 8/07/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured

Each

1,231.000

idulo 3

D3672-1

Phenolic Washer

Location	Loc Qty	Loc Code	•
FG	10		
85222	10		
ST055	1221		
103845	4		
112218	149		
<u>113581</u>	500		<u> </u>
120116	500		
80369	34		
99099	34		
	Each	0.0000	10

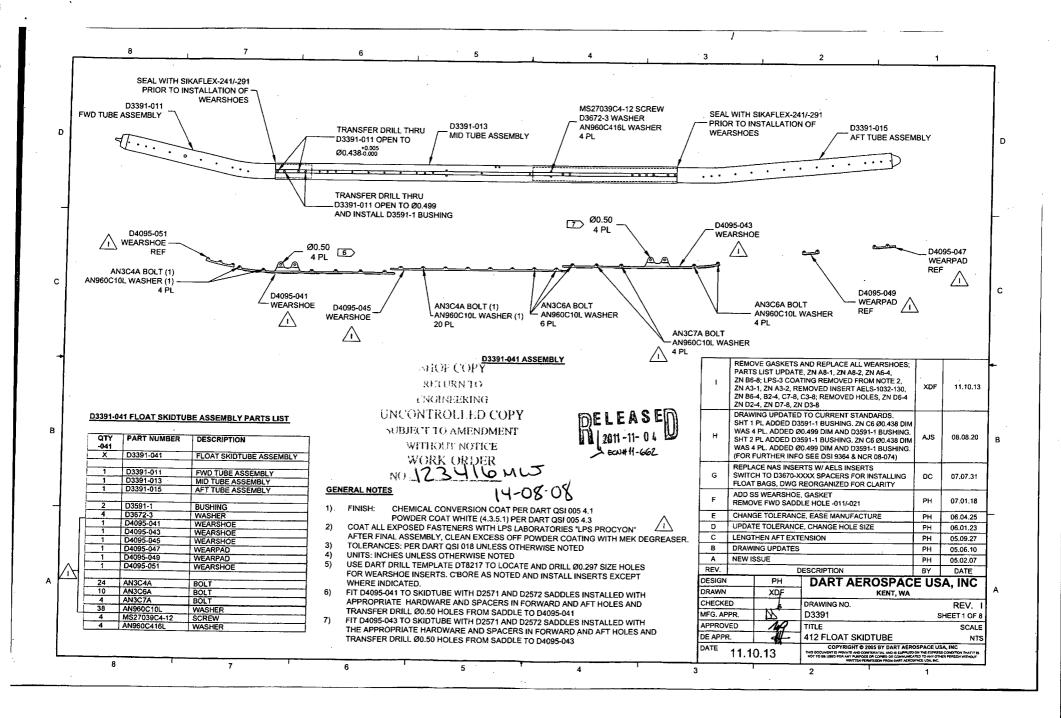
AELS-1032-225

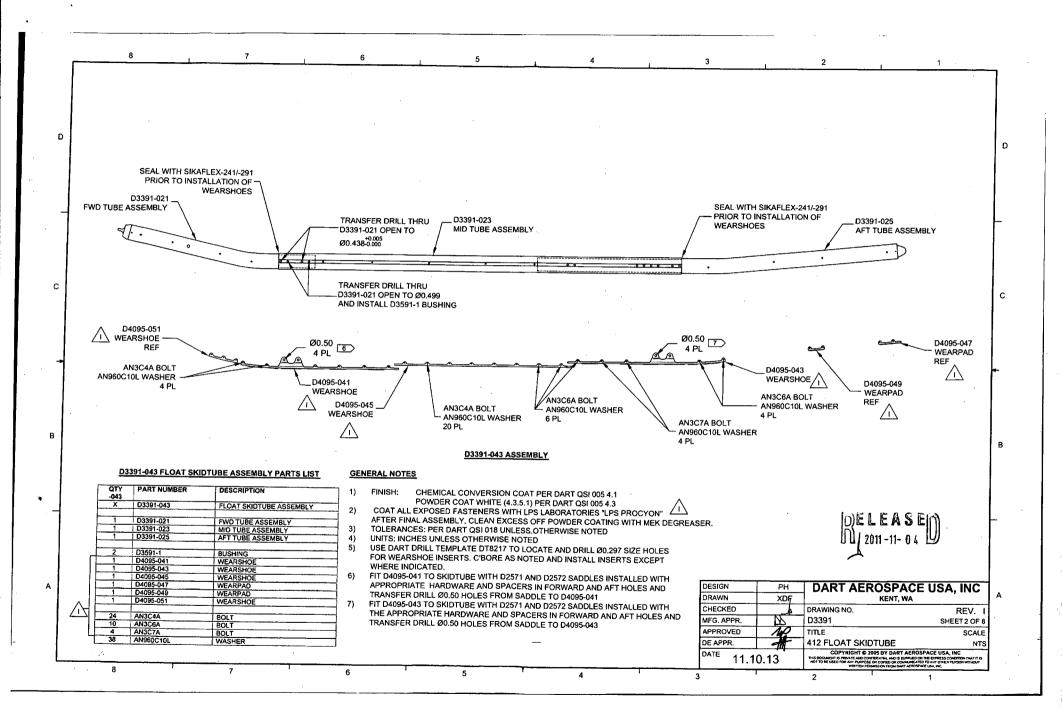
AELS8-1032-225 Purchased

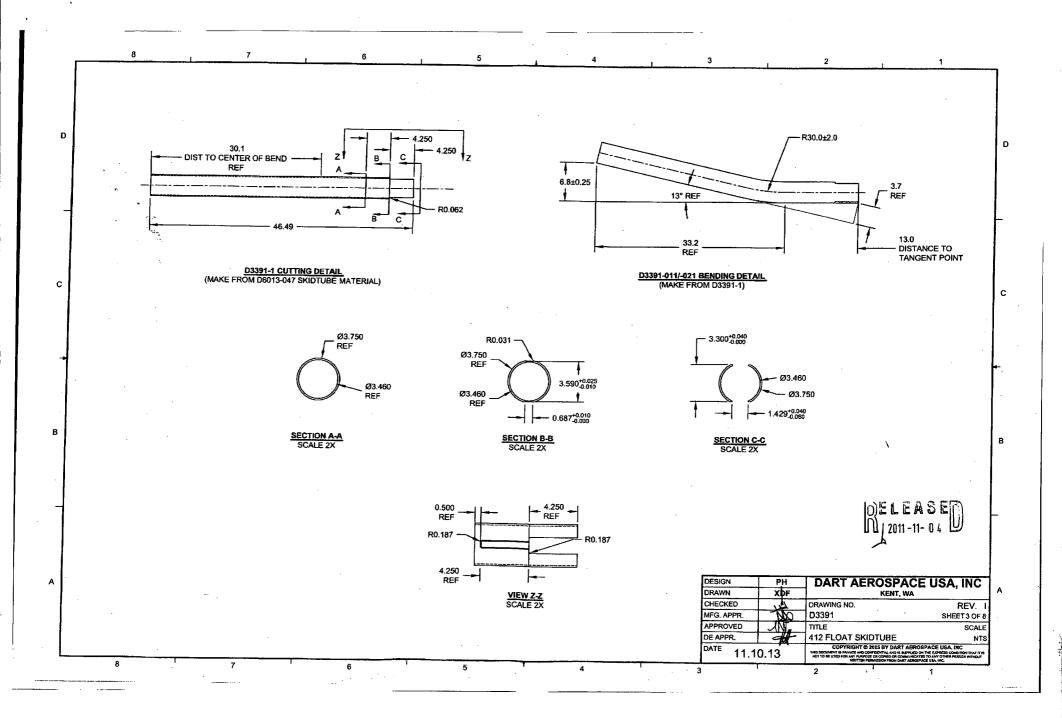
21130565(110) Il 14/11/03

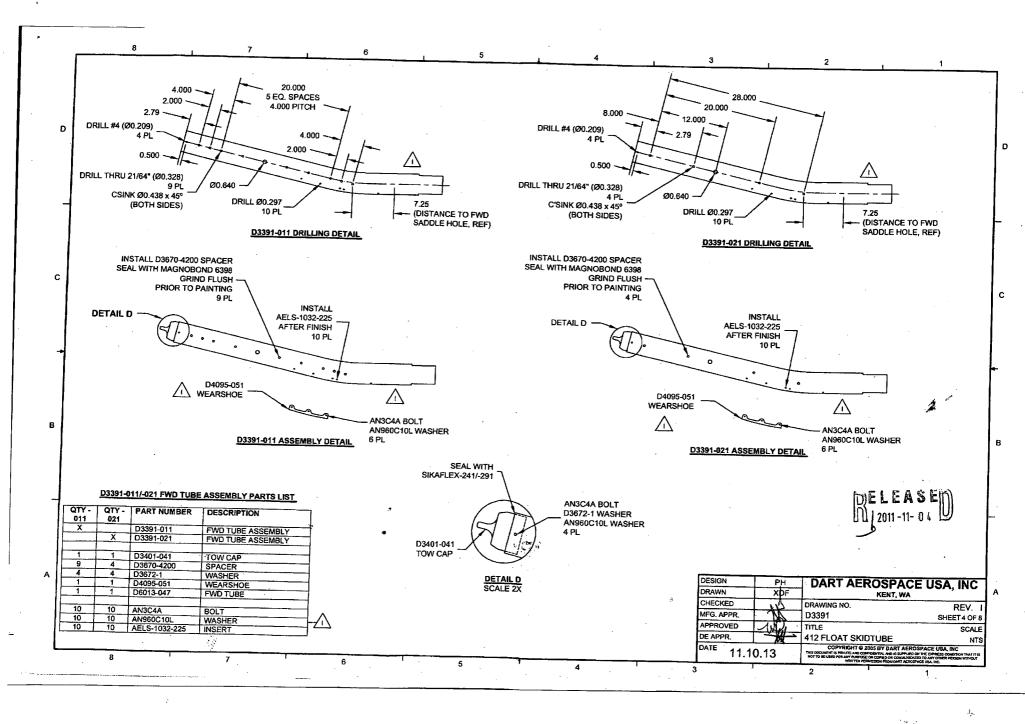
AFI S-1032-225 * ALSI-1032-225

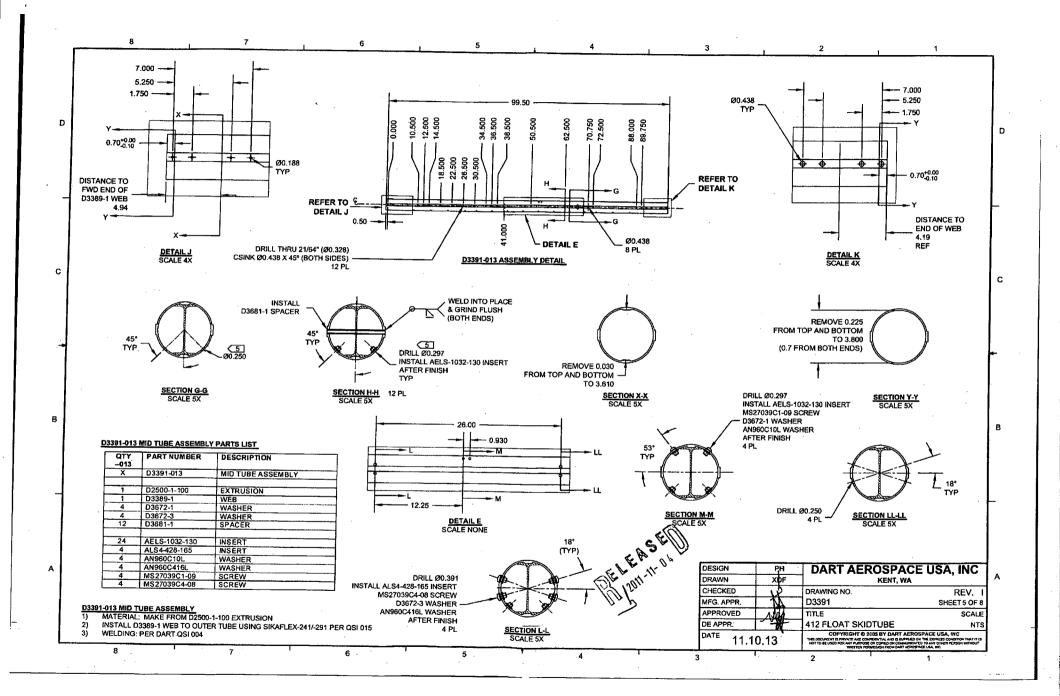
DQA: Date:				WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								DART		
QA Closed: Date:													AEROSPACE	
				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde	er: _					Damark			Skid tubo	Crosstube		Water Jet	\neg	Engineering
Part N	lo.					Rework Scrap		ı	Skid-tube Machining noforming	Small Fab Finishing	⊣	d. Eng. Coor. re/Packaging		Quality Other
NCR N	10.					Use-as-is Suspected Unapproved			Large Fab	Composite	Recyston	Supplier		
Root					Desc	ription of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	۱	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre							İ							
Material							ŀ							
Operator														
Offset/Setup														
Process														
Supplier				i										
Training														
Transport			ļ											
Unapproved														
				^			FA	ULT CAT	EGORY					
Landi	ng G	ear				General						_		
		Bending				Bend		Folio/Program			Outside Dimensions		P	ressure/Forced
		Centre Not Concentric				BOM/Route		Grain			Over/Under tolerance		s	et-up
		Cracks				Broken/Damage/Defect		Hardware			Part Incorrect			emperature/Cure
		Crimp/Kink/Ripple/Wave				Burrs		Inspection Incomplete/Unqualified			Part Lost/Missing		v	Veld
	Cuffs					Contamination		Instructions Incomplete/Unclear			Part Moved		v	Vrong Stock Pulled
		Crushing				Countersink		Misaligned/off center			Positioned Wrong			
		Heat Treat Inspection Strip in Tube				Cut Too Short		Mislabeled Misread			Power Loss/Surge			Other
						Drawing								
		Marks/Chatter				Drill Holes	Г	Off-set						
	Г	Turning S				Finish		Out of (Calibration					
	Г	Wave/Tw	•			Fit/Function		Out of S	Sequence					

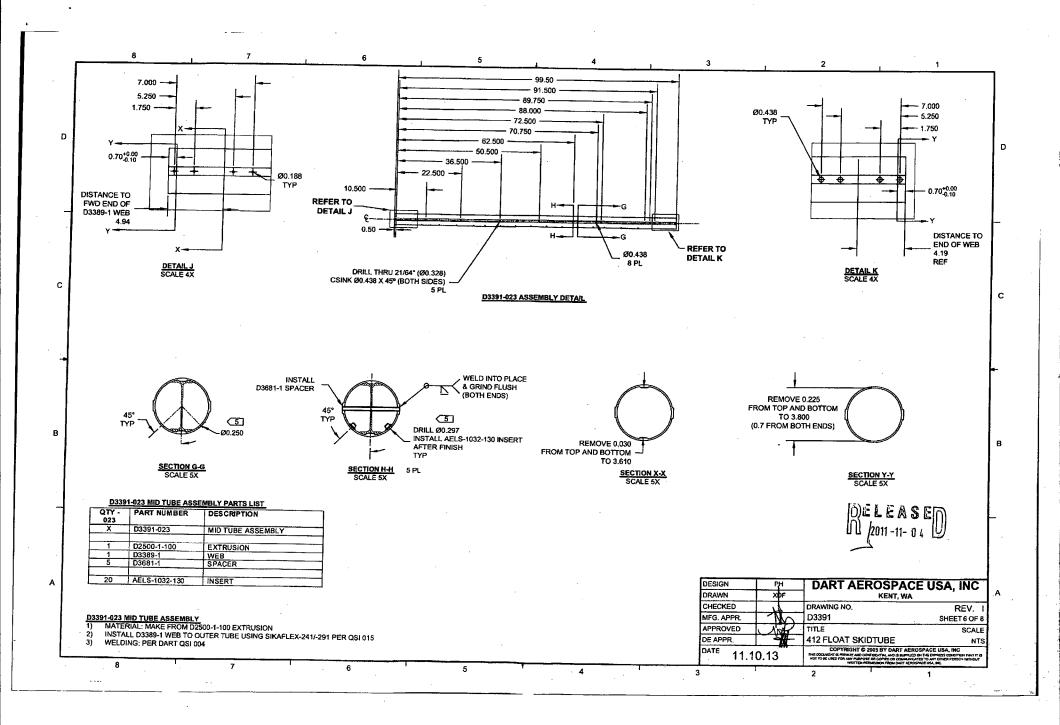


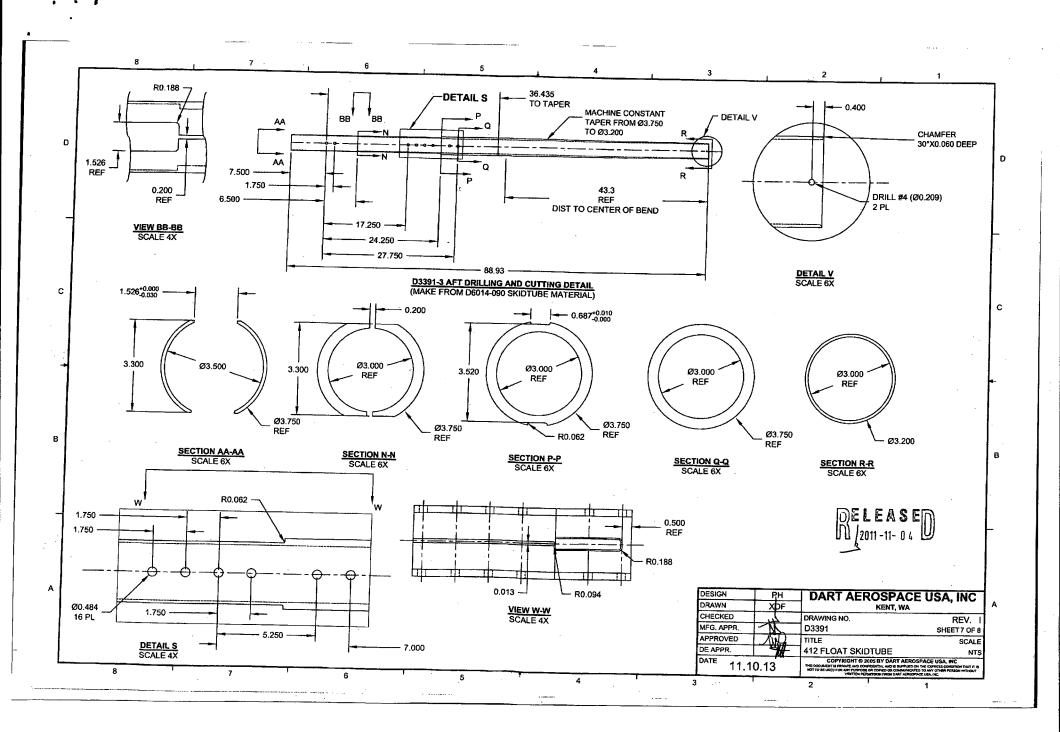


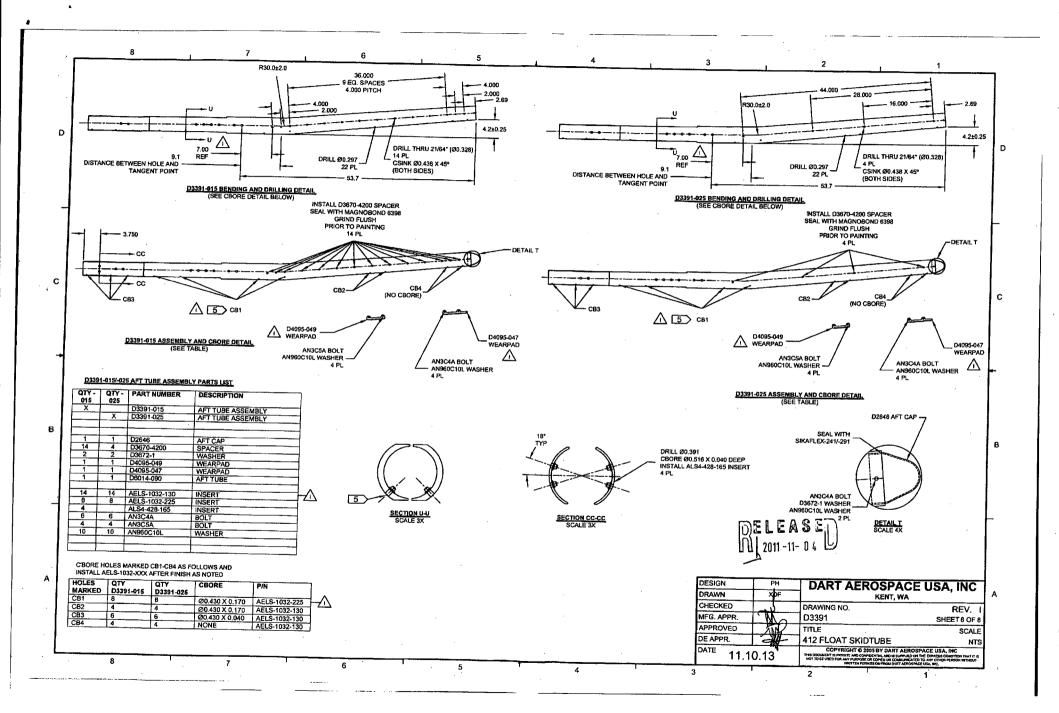












DART AEROSPACE LTD

Work Order:

Description: Float Skidtube (412)

Part Number:

D3391-1

Inspection Dwg: D3391

Rev: I

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing		Actual			Mathadas			
Dimension	Tolerance	Dimension	Accept	Reject	Method of Inspection	Comments		
0.687	+0.010/-0.000	±689	1/		CNCOZ			
3.590	+0.025/-0.010	3.595	/		1			
3.300	+0.040/-0.000	3.595 3.324	V					
1.429	+0.040/-0.060	1.427				,		
4.250	+/-0.010	4.250	1					
4.250	+/-0.010	4.250			- V			
0.500	+/-0.010	0-490	V ·		Caliper	JCL - 08		
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Measured by: 20	2 Audited by:	37 9-89	Preliminary Approval:
Date: 14-10-10/14/18/1		14.10.15	Date

Rev	Date	Change	
Α	06.04.27	New Issue P/O D3391-011/-021	Revised by 3 Approved
В	06.06.19		KJ/JLM 3)
		Tolerances revised per D3391 Rev. E	KJ/JLM %
<u> </u>	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM
D	07.11.23	Dwg Rev. updated	KJ/ECIDD A
Ë	09.12.14	Dwg Rev updated	
F	11.06.21	Dimension 0.500 added	KJ
G	12.05.15	Dwg Rev updated	KJ D F
		1 2	KU SK C